



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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D3901-043
Job Sheet 204108



POSITIVE RECALL

EFFECTIVE _____ AUTH _____
RELEASED _____ DATE _____

Part No: D3901-043

Job Qty: 12 pcs

Part Name: Wearbar Weldment



Part Weight: 0 lbs

Status: New

Job Created: 12/3/19

Job Tracking No:

Due Date: 12/18/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: URF 19-902 DWG D3901 REV.G IPP REV:A 16.06.17 NEW ISSUE DD VERF:JLM

Ship Via:

Priority: Medium

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Welded Assy- 1	12 pcs	12/18/19		0.00	2.40	Large Fab - 1		<i>RL</i>
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
110	Automated Welding - B4B	12 pcs	12/18/19		0.50	6.00	Automated Welding - 1 - B4B		<i>MZ</i>
120	QC 10	12 pcs	12/18/19		0.00	0.00	QC 10 - 10		<i>a</i>
							QC 10 - 18		
							QC 10 - 24		
							QC 10 - 43		
							QC 10 - 50		
							QC 10 - 58		
							QC 10 - 9		
							QC 10 - 68		
							QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
			12/18/19		0.00	0.00	QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		

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Container No: S272075



Part: D3901 - 043

Job No: 204108

Serial No/Batch: S272075

Revision: REV.G

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/21/20

Plex 12/3/19 8:13 AM Dart.lajeunesse.marie

				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	12
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
140 Packaging 3-1 - Stock - B4B	12 pcs	12/18/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	12
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
150 QC 21 - SA	12 pcs	12/18/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	21

APR 22 2020

APR 22 2020

Part Op 100 - 1- CUT BAR AS PER DWG (@ 67.02) 2- GRIND CHAMFERS 3- DEBURR
 Descriptions: 110 - BUILDUP HARD SURFACING 0.17 TO 0.20 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) BATCH: 11139068
 120 - (QC10- Inspect visual per QSI004- ground welds)
 130 - (QC5- Inspect part completeness to step on W/O)
 140 - (Identify as per dwg & Stock Location: MA007-3)
 150 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304B0.250x0.500	304 Bar .250 X .500	69 ft (5.75 ea)	100-Large Fab - Welded Assy-1	5253625

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	M304B0.250x0.500	69	517	0

Part Specifications

Specifications could not be found.

Plex 12/3/19 8:13 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



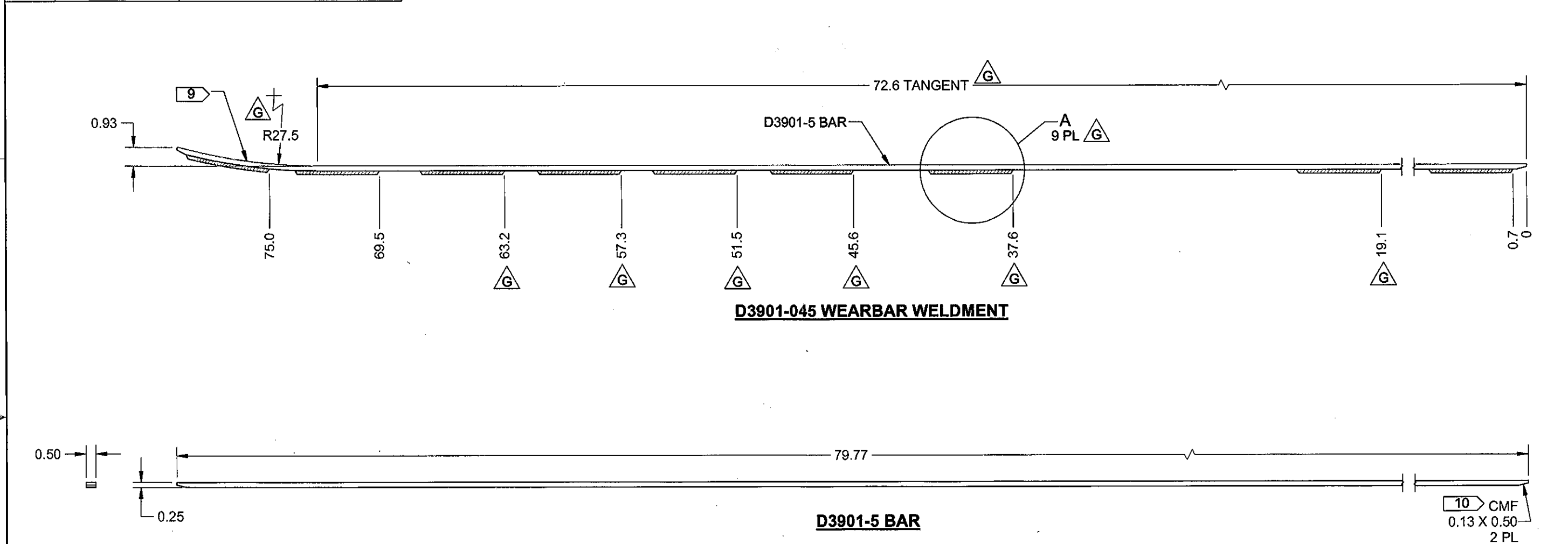
WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

QTY -045	P/N	DESCRIPTION
X	D3901-045	WEARBAR WELDMENT
1	D3901-5	BAR
A/R	8259 \ 2059B	HARD SURFACING

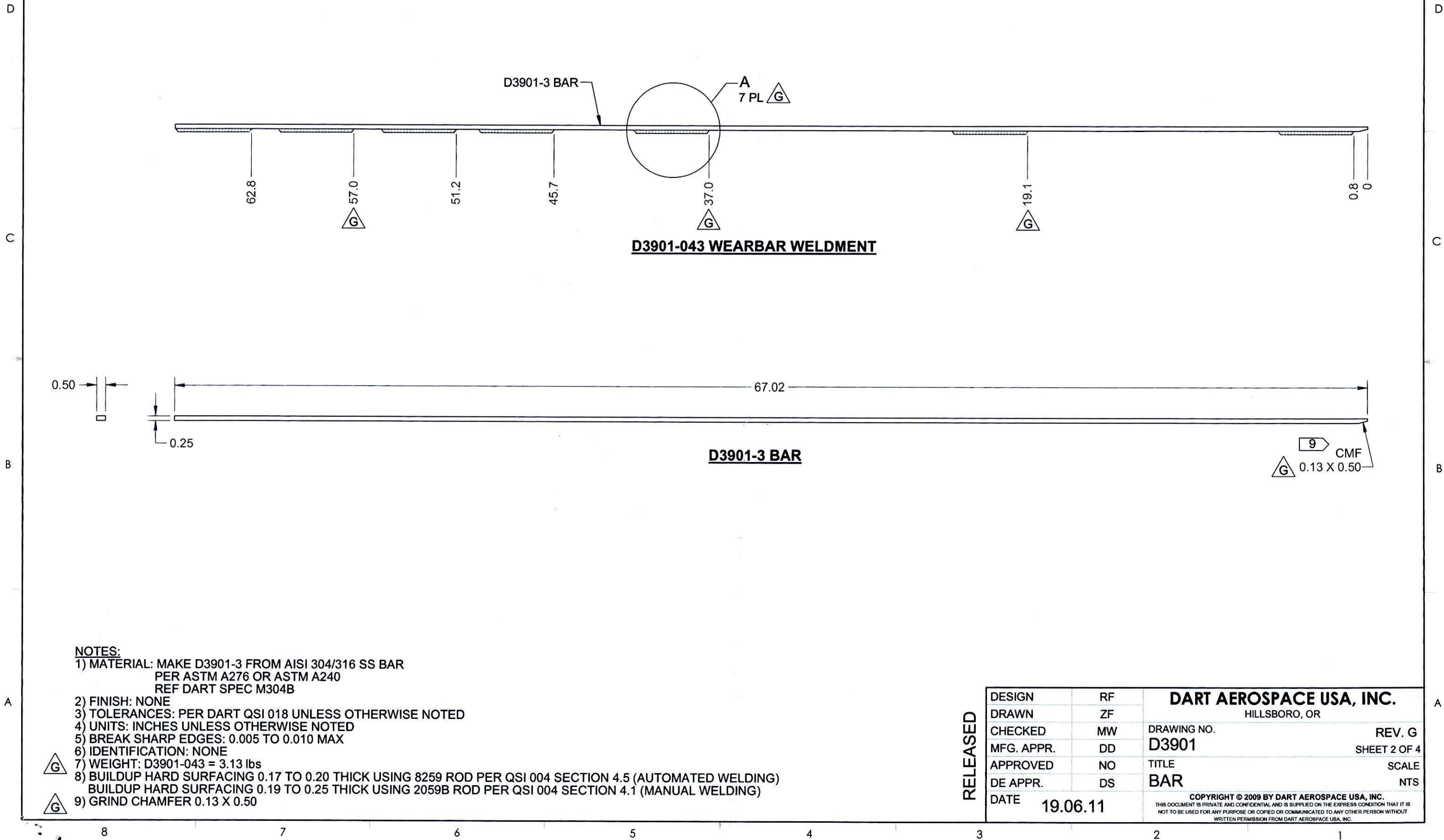


NOTES:

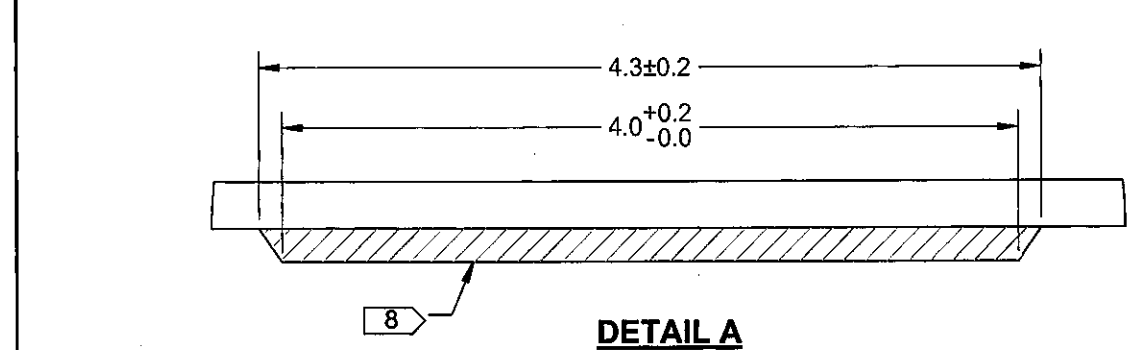
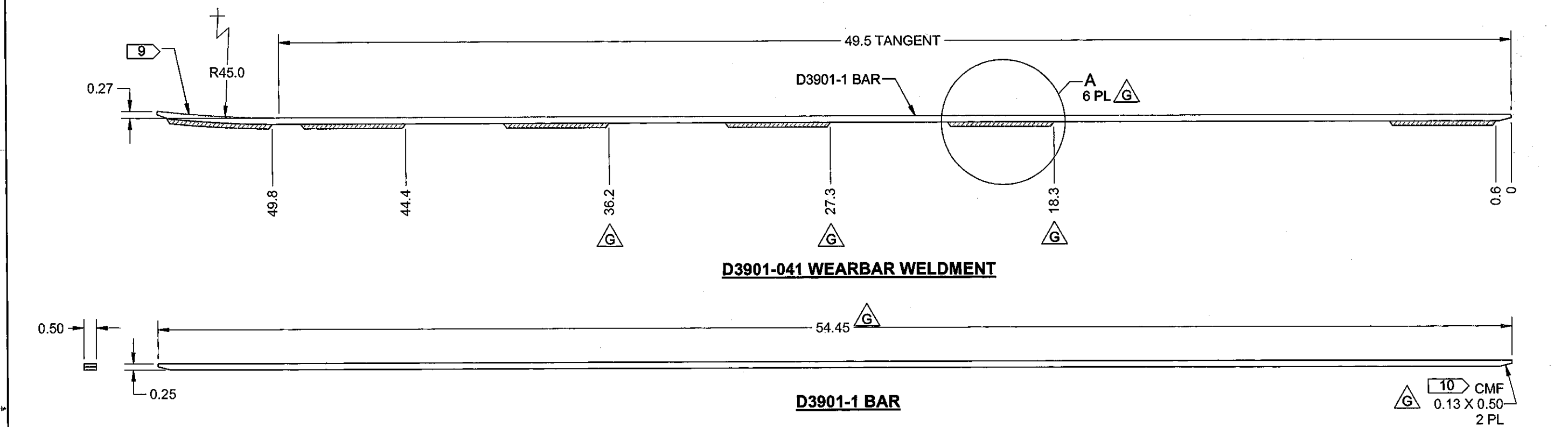
- 1) MATERIAL: MAKE D3901-5 FROM AISI 304/316 SS BAR
PER ASTM A276 OR ASTM A240
REF DART SPEC M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3901-045 = 3.80 lbs
- 8) BUILDUP HARD SURFACING 0.17 TO 0.20 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING)
BUILDUP HARD SURFACING 0.19 TO 0.25 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)
- 9) FORM D3901-045 TO FIT WEARPLATE ON FINAL ASSEMBLY
- 10) GRIND CHAMFER 0.13 X 0.50

RELEASED	DESIGN	RF	DART AEROSPACE USA, INC. HILLSBORO, OR	
	DRAWN	ZF		
	CHECKED	MW	DRAWING NO.	REV. G
	MFG. APPR.	DD	D3901	SHEET 3 OF 4
	APPROVED	NO	TITLE	SCALE
	DE APPR.	DS	BAR	NTS
	DATE	19.06.11	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

QTY -043	P/N	DESCRIPTION
X	D3901-043	WEARBAR WELDMENT
1	D3901-3	BAR
A/R	8259 \ 2059B	HARD SURFACING



QTY -041	P/N	DESCRIPTION
X	D3901-041	WEARBAR WELDMENT
1	D3901-1	BAR
A/R	8259 \ 2059B	HARD SURFACING



- NOTES:
- 1) MATERIAL: MAKE D3901-1 FROM AISI 304/316 SS BAR PER ASTM A276 OR ASTM A240 REF DART SPEC M304B
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: D3901-041 = 2.58 lbs
 - 8) BUILDUP HARD SURFACING 0.17 TO 0.20 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) BUILDUP HARD SURFACING 0.19 TO 0.25 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)
 - 9) FORM D3901-041 TO FIT WEARPLATE ON FINAL ASSEMBLY
 - 10) GRIND CHAMFER 0.13 X 0.50

G	REDRAWN TO CURRENT STANDARDS. REVISE HARD SURFACING POSITIONS/QTY FOR BETTER WEAR RESISTANCE REF CAR19-319. CHANGE LENGTH OF -1 TO MATCH WEARPLATE. ADDED -047/-7	ZF	19.06.11
F	SEE D3901-1F/-3/-5F GROOVES REMOVED SEE REV E FOR FURTHER DETAILS. ADDED D3901-041/-043/-045. 1B7 ADDED DETAIL A; 3A7 ADDED DETAIL C; 4B4 ADDED DETAIL D; 5B5 ADDED DETAIL E 6BA ADDED DETAIL F. WELDING SLOTS REMOVED. NOTE 8 RE-WRITTEN FOR NEW PROCESS. 4D4 DIM WAS 54.2. 5D4 DIM WAS 66.87.	AJS	16.01.04
E	CHANGE LOCATION OF END POCKETS ON -1/-3/-5 (ZN B1-2, D8-2, B7-3, B2-3, D1-4, D7-4).	DC	12.08.23
D	CHANGE LOCATION OF END POCKETS ON -1/-3/-5 (ZN D1-2, D8-2, B7-3, B2-3, D1-4, D8-4). SPLIT POCKETS INTO TWO SEPARATE POCKETS (ZN A2-2). ADD POCKET TO -1 (ZN D6-2).	DC	12.08.21
C	0.25 WAS 0.20 AND 0.130 WAS 0.080 (ZN B2-2, B1-2, B1-3, D8-4); ADD MISSING DIMENSIONS (ZN C5-3); ADD D3901-1F/-5F FLAT PATTERN	RF	12.01.24
B	REMOVE Ø0.188 HOLES FROM D3901-1/-3/-5; 62.12 WAS 62.61 (ZN C4-3)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. HILLSBORO, OR	
DRAWN	ZF		
CHECKED	MW	DRAWING NO.	REV. G
MFG. APPR.	DD	D3901	SHEET 1 OF 4
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	BAR	NTS
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